

Claims

1. Method for the production of a cooled ring insert (1), consisting of a gray casting alloy having a nickel content, for an aluminum piston of an internal combustion engine, to be produced using the casting method, having a cooling channel (6) formed on the ring insert back (3), as a turned groove (4) that is open towards the bottom, **characterized by** the following steps:
 - salt granulate is pressed into the turned groove (4) at a pressure of 100 to 300 N/mm², so that a salt core (5) is formed in the turned groove (4);
 - the combination consisting of the ring insert (1) and the salt core (5) is pre-heated to a temperature of 200°C to 250°C;
 - the combination consisting of the ring insert (1) and the salt core (5) is dipped into an alfin bath consisting of an aluminum melt.
2. Method for the production of a cooled ring insert (1) as recited in claim 1, **characterized in that** the combination consisting of the ring insert (1) and the salt core (5)

combination is dipped into an alfin bath consisting of an aluminum melt for $2\frac{1}{2}$ to $5\frac{1}{2}$ minutes.

3. Method for the production of a cooled ring insert (1) as recited in claim 1 or 2, **characterized in that** a finished, pressed salt core (5) is placed into the turned groove (4), and attached in the holder (4) by means of an adhesive bond.